

Date: Thursday, 4/12/2007 9:33:48 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LABEL PLATE
Job Number	: 31786		
Estimate Number	: 10599		
P.O. Number	: <i>N/A</i>	Part Number	: D2506
This Issue	: 4/12/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2506 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: E
Previous Run	: 30548	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 5/10/2007 Qty: 25 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est. B 01.06.08 Now laser cut EC est C 06.12.13 ecn 822 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 1.2810 sf(s)/Unit Total : 32.0250 sf(s)

304/316 .040 Sheet

Batch: *M101873 9*

M101463 1 M103713 4
M101264 7 M104640 4

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

SAD 07/06/24

(25)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/06/24 (25)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/06/25 (25)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

SAD 07/06/25 (25)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 62 Date: 01/07/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:33:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LABEL PLATE

Job Number: 31786

Part Number: D2506

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per dwg D2506

SB 07/07/05 (25)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/05

(XZ) Comto

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51235

Pc 7/7/9 (25)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(25)
HP 07/07/05

Job Completion



C 07/07/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31786
Description: Label Plate		Part Number:	D2506
Inspection Dwg: D2506 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.63	+/-0.030	32.625	/		M-T	
39.00	+/-0.030	39.00	/		M-T	
4.50	+/-0.030	4.502	/		Vern	
1.31	+/-0.030	1.315	/		Vern	
1.88	+/-0.030	1.874	/		Vern	
0.040	+/-0.010	0.036	/		Vern	

Measured by: SAD	Audited by: EV	Prototype Approval:	N/A
Date: 07/06/24	Date: 07/06/25	Date:	N/A

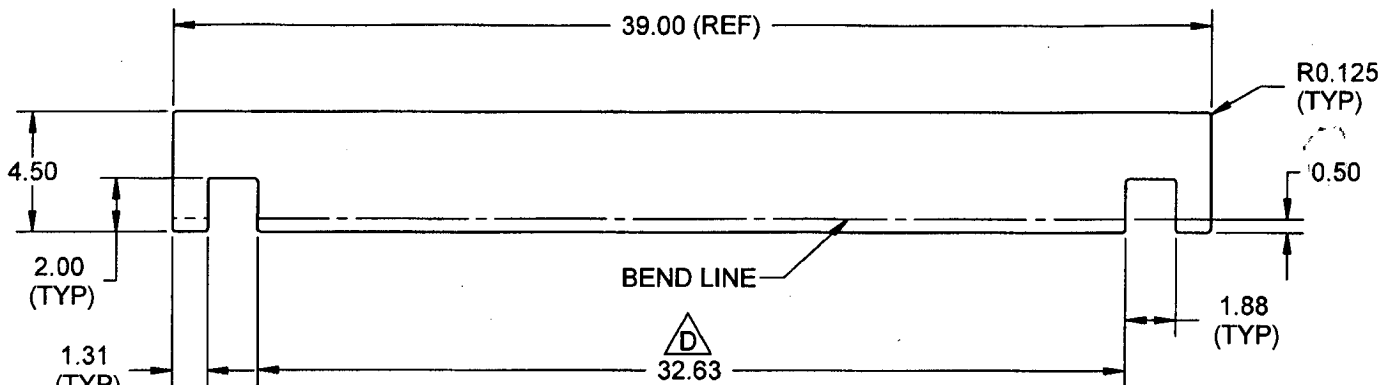
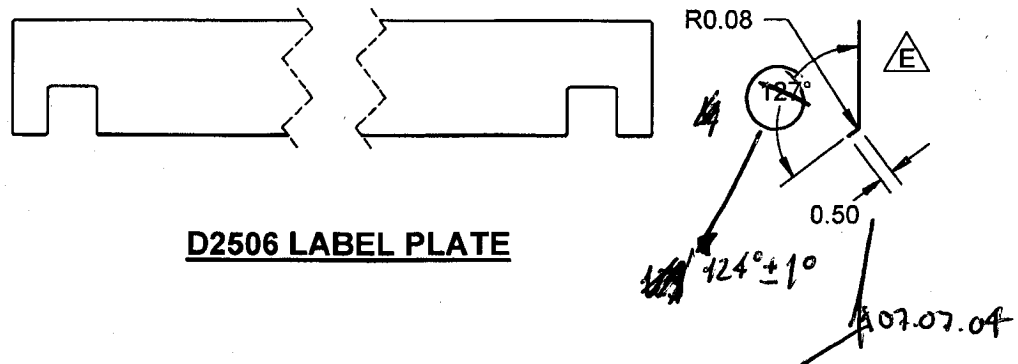
Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	
B	06.12.20	Dwg Rev. updated	KJ/JLM	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D2506	REV. E SHEET 1 OF 1
DATE 06.11.20	TITLE LABEL PLATE		SCALE 1:7
REV	DATE	DESCRIPTION	
A	95.11.26	NEW ISSUE	
B	96.06.18	RE-DESIGN OF LABEL PLATE	
C	96.09.04	RE-DESIGN OF LABEL PLATE	
D	99.10.04	32.63 WAS 32.25; 1.31 WAS 1.50	
E	06.11.20	REMOVE 10° BEND; ADD NOTES; 127° WAS 126°	

RELEASED

06.11.28

**D2506F FLAT PATTERN****D2506 LABEL PLATE**

E

NOTES:

- 1) MATERIAL: STAINLESS STEEL AISI 304/316 SHEET 0.040 THICK PER MIL-S-5019 (REF DART SPEC M304S20GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31786

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